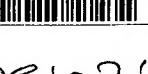


Date: Friday, 07/07/2006 8:59:10 AM  
User: Linda Lacelle

## **Process Sheet**

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: SPACER KIT		
Job Number	: 27583			Part Number	: D25251		
Estimate Number	: 11799			Drawing Number	: D2525 REV B		
P.O. Number	: N/A			Project Number	: N/A		
This Issue	: 07/07/2006	S.O. No.	: N/A	Drawing Revision	: B		
Prsht Rev.	: NC			Material	: N/A		
First Issue	: 15/06/2006	Type	: PURCHASED PARTS	Due Date	: 30/06/2006		
Previous Run	: N/A			Qty:	20	Um:	Each
Written By	: See comment below						
Checked & Approved By	: [Signature]						
Comment	: Est. B99.11.10 Re-format added Acid etch stepEC						
<b>Additional Product</b>							
Job Number: 							
<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>					
1.0	M6061T6R0750	6061-T6 Round Bar .750"					
							
Comment: Qty.: 0.0620 f(s)/Unit Total : 1.2400 f(s) 6061-T6 Round Bar .750" <i>M100157</i> <i>900 06/07/11</i>							
2.0	LATHE CONV.	CONVENTIONAL LATHE					
							
Comment: CONVENTIONAL LATHE <i>900 06/07/11 20</i>							
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE					
							
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>900 06/07/11 20</i>							
4.0	QC8	SECOND CHECK					
							
Comment: SECOND CHECK <i>5-G 06/07/11 20</i>							
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1					
							
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 <i>SAD 06/07/11 20</i>							
6.0	<i>QC5</i> <i>QEB</i>	INSPECT WORK TO CURRENT STEP					
							
Comment: INSPECT WORK TO CURRENT STEP <i>J6/07/12 20</i>							

Date: Friday, 07/07/2006 8:59:10 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER KIT

Job Number: 27583

Part Number: D25251

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST47

SL 06/07/12 (45)

8.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

(20) 06/07/13

Job Completion



W 06-07-13

Date: Thursday, 6/15/2006 1:50:29 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SPACER KIT		
Job Number	: 27583					
Estimate Number	: 11799					
P.O. Number	:			Part Number	: D25251	
This Issue	: 6/15/2006		S.O. No. :	Drawing Number	: D2525 REV B	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type :	Drawing Revision	: B	
Previous Run	:			Material	:	
Written By	:			Due Date	: 6/30/2006	
Checked & Approved By	: <u>DK</u> 06.06.15			Qty:	20	Um: Each
Comment	: Est. B99.11.10 Re-format added Acid etch stepEC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
		<i>Material: 6061-T6, Ø .750"</i>
		<i>(.062 foot).</i>
		<i>Issue P/O: _____ Batch: _____</i>
		<i>Make as per Dwg D2525</i>
		<i>Material release note required</i>
2.0	D2525TP	Conventional Lathe.
		<i>Spacer Kit</i>
		<i>Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)</i>
		<i>Spacer Kit</i>
3.0	PACKAGING QCZ	PACKAGING RESOURCE #1
		<i>Comment: PACKAGING RESOURCE #1</i>
		<i>Recieve &amp; Inspect for Transit Damage</i>
		<i>Ensure Material Release Note is attached</i>
4.0	Q00	DIMENSIONAL CHECK
		<i>QC8</i>
		<i>Comment: DIMENSIONAL CHECK</i>
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		<i>Comment: HAND FINISHING RESOURCE #1</i>
		<i>Acid etch and Alodine as per QSI 005 4.1</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Thursday, 6/15/2006 1:50:29 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER KIT

Job Number: 27583

Part Number: D25251

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 ~~QC3~~ *Inspect thermal conversion.* INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

8.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_

PAR #: \_\_\_\_\_

Fault Category: \_\_\_\_\_

NCR:

Yes

No

DQA: 

Date: 06/07/13

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_

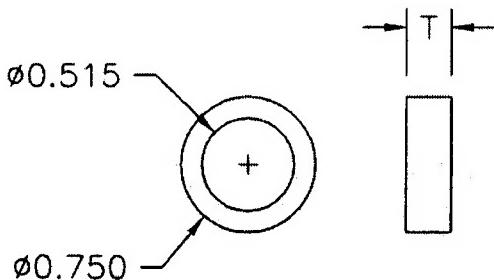
Date: \_\_\_\_\_

**DART**

DESIGN BW	DRAWN BY <i>RF</i>	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>HF</i>	DRAWING NO. D2525	REV. B SHEET 1 OF 1
DATE 99.09.30		TITLE SPACER KIT	SCALE 1:1
A	95.12.22	NEW ISSUE	
B	99.09.30	REVISED MATERIAL	

**RELEASED**  
 99.10.12 *KE*

PART NUMBER	THICKNESS T	QTY
D2525-1	0.750	1
D2525-3	0.250	1
D2525-5	0.125	4
D2525-7	0.063	0
D2525-9	0.032	0



MATERIAL: 5052-H32 (QQ-A-225/7) OR 1100 (QQ-A-225/1)  
 OR 6061-T6 (QQ-A-225/8) OR 6061-T6 (QQ-A-200/8)  
 FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. *27583*

DART AEROSPACE LTD	Work Order:	27583
Description: SPACER	Part Number:	D25251
Inspection Dwg: D2525, Rev: B		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article X Prototype

Measured by:		Audited by:		Prototype Approval:	
Date:	06/07/11	Date:	06-07-11		Date:

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A		New Issue	KJ/JLM	